

# Work Order ID 98161

March-08-13 9:52:52 AM

**\*98161\***

Page 1

Item ID: D2932-1

Revision ID:

Item Name: Saddle LH Out. 206

Start Date: 3/08/13 Start Qty: 12.00

Required Date: 3/29/13 Req'd Qty: 12.00

Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: *B-03-F*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description  | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| <b>Draw Nbr</b>                | <b>Revision Nbr</b>   |                      |         |        |              |               |               |                  |                |
| D2932                          | Rev C   |                      |         |        |              |               |               |                  |                |
| 100                            |   | 0.00                 |         |        |              |               |               |                  |                |
| <b>*100*</b>                   | HAAS CNC VERTICAL MACHINING #1  |                      |         |        |              |               |               |                  |                |
| HAAS I                         |   | 0.00                 |         |        |              |               |               |                  |                |
| HAAS CNC vertical machine #1   | <p><b>Memo</b></p> <p>Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 &amp; attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per</p> |                      |         |        |              |               |               |                  |                |
|                                |   |                      |         |        |              |               |               |                  |                |
| 110                            |   | 0.00                 |         |        |              |               |               |                  |                |
| <b>*110*</b>                   | CONVENTIONAL MILLING MACHINE  |                      |         |        |              |               |               |                  |                |
| Mill Conv                      |   | 0.00                 |         |        |              |               |               |                  |                |
| Conventional Milling Machine   | <p><b>Memo</b></p> <p>Machine Keyway and inspect per attached dimension sheet</p>   |                      |         |        |              |               |               |                  |                |
|                                |   |                      |         |        |              |               |               |                  |                |
| 120                            |   | 0.00                 |         |        |              |               |               |                  |                |
| <b>*120*</b>                   | QC1- Inspect dimensions to dimension sheet  |                      |         |        |              |               |               |                  |                |
| QC                             |   | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                | <p><b>Memo</b></p>  |                      |         |        |              |               |               |                  |                |

*PO 13/04/22*  
*FK 13/04/23*

*PO 13/04/22*  
*FK 13/04/23*

*PO 13/04/22*  
*FK 13/04/23*

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |      |      |     |   |                      |   |                |              |              |  |  |
|--|------|------|-----|---|----------------------|---|----------------|--------------|--------------|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ |      |      |     | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                |              |              |  |  |
| <b>Root Cause</b>  | Date | Step | Qty | Description of work order update<br>or Non-conformance  | Initial<br>Chief Eng | Action<br>Description   | Sign &<br>Date | Verification | QC Inspector |  |  |
| Doc/Data <input type="checkbox"/>                            |      |      |     |   |                      |   |                |              |              |  |  |
| Equip/Tooling <input type="checkbox"/>                       |      |      |     |   |                      |   |                |              |              |  |  |
| Operator <input type="checkbox"/>                            |      |      |     |   |                      |   |                |              |              |  |  |
| Material <input type="checkbox"/>                            |      |      |     |   |                      |   |                |              |              |  |  |
| Setup <input type="checkbox"/>                               |      |      |     |   |                      |   |                |              |              |  |  |
| Other <input type="checkbox"/>                               |      |      |     |   |                      |   |                |              |              |  |  |
| Process <input type="checkbox"/>                             |      |      |     |   |                      |   |                |              |              |  |  |
| Supplier <input type="checkbox"/>                            |      |      |     |   |                      |   |                |              |              |  |  |
| Training <input type="checkbox"/>                            |      |      |     |   |                      |   |                |              |              |  |  |
| Unapproved <input type="checkbox"/>                          |      |      |     |   |                      |   |                |              |              |  |  |

| FAULT CATEGORY  |   |   |  |   |
|---|---|---|--|---|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other |

# Work Order ID 98161

March-08-13 9:52:52 AM

**\*98161\***

Page 2

Item ID: D2932-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle LH Out. 206

Start Date: 3/08/13 Start Qty: 12.00 **\*12\***

Cust Item ID:

Required Date: 3/29/13 Req'd Qty: 12.00 **\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                      | Operation<br>Description   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130<br><b>*130*</b><br>QC<br>Quality Control        | QC8- Inspect parts - second check<br><br>Memo  | 0.00<br><br>0.00     |         |        |              | 12            | 0             |                  |                |
| 140<br><b>*140*</b><br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>Memo  | 0.00<br><br>0.00     |         |        |              | 12            |               | 13-56            |                |
| 155<br><b>*155*</b><br>SprayPaint<br>Spray Painting | Spray Painting per QSI005 4.2<br><br>Memo<br>PRIME B/125152<br>DELFLEET BLUE B/125476<br>DELFLEET CLEAR B/125053<br>START TIME: 11:00<br>FINISH TIME: 5:30 | 0.00<br><br>0.00     |         |        |              | 12            |               | J.P.<br>13-05-10 | P.T.O.         |

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Adh Date: 13/06/07QA Closed: CK Date: 13/6/4

|                          |  |  |   |  |                                      |
|--------------------------|--|--|---|--|--------------------------------------|
| Work Order: <u>98161</u> | <b>DISPOSITION</b><br>Rework <input checked="" type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b>      |   |  |                                      |
| Part No. <u>D2932-1</u>  |  | Skid-tube <input type="checkbox"/>     | Crosstube <input type="checkbox"/>            | Water Jet <input type="checkbox"/>           | Engineering <input type="checkbox"/> |
| NCR No. <u>13-2694</u>   |  | Machining <input type="checkbox"/>     | Small Fab <input checked="" type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/>   | Quality <input type="checkbox"/>     |
|                          |  | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/>            | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>       |
|                          |  | Large Fab <input type="checkbox"/>     | Composite <input type="checkbox"/>            | Supplier <input type="checkbox"/>            |                                      |

| Root Cause    | Date            | Step         | Qty       | Description of work order update or Non-conformance   | Initial Chief Eng                                     | Action Description   | Sign & Date                 | Verification                          | QC Inspector   |
|---------------|-----------------|--------------|-----------|---|---|--|-----------------------------|---------------------------------------|--|
| Doc/Data      | <u>13/05/13</u> | <u># 155</u> | <u>12</u> | Found Qty +2 with marks + scratches.<br>RC not placed in Boxes to avoid marks / each & cont storage transport | <u>DAS 16 8-0</u><br><u>Q52042</u><br><u>13/05/13</u> | Strip + Repair<br>As per as 2005 + 200<br>Day. unable to touch up<br>will look unprofessional<br>Blue 125476<br>clear 125385 | <u>AG</u><br><u>13-5-13</u> | <u>DAS 05 8-05</u><br><u>13-05-28</u> | <u>DAS 16 8-05</u><br><u>Q52042</u><br><u>13/05/13</u> |
| Equip/Tooling |                 |              |           |   |   |  |                             |                                       |  |
| Operator      |                 |              |           |   |   |  |                             |                                       |  |
| Material      |                 |              |           |   |   |  |                             |                                       |  |
| Setup         |                 |              |           |   |   |  |                             |                                       |  |
| Other         |                 |              |           |   |   |  |                             |                                       |  |
| Process       |                 |              |           |   |   |  |                             |                                       |  |
| Supplier      |                 |              |           |   |   |  |                             |                                       |  |
| Training      |                 |              |           |   |   |  |                             |                                       |  |
| Unapproved    |                 |              |           |   |   |  |                             |                                       |  |

## FAULT CATEGORY

| Landing Gear  | General  |
|---|--|
| <input type="checkbox"/> Bending                      | <input type="checkbox"/> Bend                            |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route                       |
| <input type="checkbox"/> Cracks                       | <input type="checkbox"/> Broken/Damaged                  |
| <input type="checkbox"/> Crushed/Crimped              | <input type="checkbox"/> Burrs                           |
| <input type="checkbox"/> Cuffs                        | <input type="checkbox"/> Contamination                   |
| <input type="checkbox"/> Heat Treat                   | <input type="checkbox"/> Countersink                     |
| <input type="checkbox"/> Inspection Strip in Tube     | <input type="checkbox"/> Cut Too Short                   |
| <input type="checkbox"/> Ripples in Bend              | <input type="checkbox"/> Drill Holes                     |
| <input type="checkbox"/> Torque Waves in Extrusion    | <input type="checkbox"/> Drawing                         |
| <input type="checkbox"/> Turning Sequence             | <input type="checkbox"/> Finish                          |
| <input type="checkbox"/> Wave/Twist in Tube           | <input type="checkbox"/> Folio                           |
|   | <input type="checkbox"/> Grain                           |
|   | <input type="checkbox"/> Hardware                        |
|   | <input type="checkbox"/> Inspection Incomplete           |
|   | <input type="checkbox"/> Instructions Incomplete/Unclear |
|   | <input type="checkbox"/> Maintenance                     |
|   | <input type="checkbox"/> Misabeled                       |
|   | <input type="checkbox"/> Misread                         |
|   | <input type="checkbox"/> Offset                          |
|   | <input type="checkbox"/> Out of Calibration              |
|   | <input type="checkbox"/> Out of Sequence                 |
|   | <input type="checkbox"/> Outside Dimensions              |
|   | <input type="checkbox"/> Ovalized                        |
|   | <input type="checkbox"/> Over/Under tolerance            |
|   | <input type="checkbox"/> Part Incorrect                  |
|   | <input type="checkbox"/> Part Lost/Missing               |
|   | <input type="checkbox"/> Part Moved                      |
|   | <input type="checkbox"/> Positioned Wrong                |
|   | <input type="checkbox"/> Power Loss/Surge                |
|   | <input type="checkbox"/> Pressure/Forced                 |
|   | <input type="checkbox"/> Temperature/Cure                |
|   | <input type="checkbox"/> Weld                            |
|   | <input type="checkbox"/> Wrong Stock Pulled              |
|   | <input type="checkbox"/> Other                           |

# Work Order ID 98161

March-08-13 9:52:52 AM

**\*98161\***

Page 3

Item ID: D2932-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle LH Out. 206

Start Date: 3/08/13 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 3/29/13 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

165

QC14- Inspect Spray Paint

0.00

**\*165\***

QC

Memo

0.00

Quality Control

12

DAS  
05  
8-88

13-05-28

170

Identify as per dwg & Stock Location **ST 427** 0.00

**\*170\***

Packaging

Memo

0.00

Packaging

12x

SP  
13-5-30

180

QC21- Final Inspection - Work Order Release 0.00

**\*180\***

QC

Memo

0.00

Quality Control

13/6/3

MF

13-5-31

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |   |   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>  | Water Jet <input type="checkbox"/>  | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>  | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/>  | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>  | Supplier <input type="checkbox"/>   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |

| Root Cause    | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Setup         |      |      |     |   |                   |                    |             |              |              |
| Other         |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

### FAULT CATEGORY

|   |   |  |
|---|---|--|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions<br><br><input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |
|---|---|--|

# Picklist Print

March-08-13 9:52:56 AM

Page 1

Work Order ID: 98161

\*98161\*

Parent Item: D2932-1

\*D2932-1\*

Parent Item Name: Saddle LH Out, 206

Start Date: 3/08/13

Required Date: 3/29/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B00.06.26New DWG rev, (mpp 2069)EC  
IPP Rev:C As per Rev C 07-03-19 JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-003                       |                        | Manufactured  | No          |                     |                  | 100             | Each               | 0.0000         | 1           | 12           |               |                |        |

\*D6101-003\*

Saddle Billet, 7075

\*\*

PO 13/04/21

→ 98417

12

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |   |   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>  | Water Jet <input type="checkbox"/>  | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>  | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/>  | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>  | Supplier <input type="checkbox"/>   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |

| Root Cause    | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Setup         |      |      |     |   |                   |                    |             |              |              |
| Other         |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

### FAULT CATEGORY

| Landing Gear  | General                                 | Other  |
|---|---|--|
| <input type="checkbox"/> Bending                      | <input type="checkbox"/> Bend           | <input type="checkbox"/> Grain                           |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route      | <input type="checkbox"/> Hardware                        |
| <input type="checkbox"/> Cracks                       | <input type="checkbox"/> Broken/Damaged | <input type="checkbox"/> Inspection Incomplete           |
| <input type="checkbox"/> Crushed/Crimped              | <input type="checkbox"/> Burrs          | <input type="checkbox"/> Instructions Incomplete/Unclear |
| <input type="checkbox"/> Cuffs                        | <input type="checkbox"/> Contamination  | <input type="checkbox"/> Maintenance                     |
| <input type="checkbox"/> Heat Treat                   | <input type="checkbox"/> Countersink    | <input type="checkbox"/> Mislabeled                      |
| <input type="checkbox"/> Inspection Strip in Tube     | <input type="checkbox"/> Cut Too Short  | <input type="checkbox"/> Misread                         |
| <input type="checkbox"/> Ripples in Bend              | <input type="checkbox"/> Drill Holes    | <input type="checkbox"/> Offset                          |
| <input type="checkbox"/> Torque Waves in Extrusion    | <input type="checkbox"/> Drawing        | <input type="checkbox"/> Out of Calibration              |
| <input type="checkbox"/> Turning Sequence             | <input type="checkbox"/> Finish         | <input type="checkbox"/> Out of Sequence                 |
| <input type="checkbox"/> Wave/Twist in Tube           | <input type="checkbox"/> Folio          | <input type="checkbox"/> Outside Dimensions              |
|   |   | <input type="checkbox"/> Ovalized                        |
|   |   | <input type="checkbox"/> Over/Under tolerance            |
|   |   | <input type="checkbox"/> Part Incorrect                  |
|   |   | <input type="checkbox"/> Part Lost/Missing               |
|   |   | <input type="checkbox"/> Part Moved                      |
|   |   | <input type="checkbox"/> Positioned Wrong                |
|   |   | <input type="checkbox"/> Power Loss/Surge                |
|   |   | <input type="checkbox"/> Pressure/Forced                 |
|   |   | <input type="checkbox"/> Temperature/Cure                |
|   |   | <input type="checkbox"/> Weld                            |
|   |   | <input type="checkbox"/> Wrong Stock Pulled              |
|   |   | <input type="checkbox"/> Other                           |



|   |                     |             |
|---|---------------------|-------------|
| <b>DART AEROSPACE LTD</b>                           | <b>Work Order:</b>  | 98161       |
| <b>Description:</b> 206 Saddle, Outboard, Left side | <b>Part Number:</b> | D2932-1     |
| <b>Inspection Dwg:</b> D2932 Rev. C                 |                     | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

|               |       |       |                | Recorded Actual Dimensions |       |       |       |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2     | 3     | 4     | By | Date |
| A             | 0.100 | 0.140 |                | .115                       | .111  | .114  | .111  |    |      |
| B             | 0.100 | 0.140 |                | .115                       | .114  | .114  | .111  |    |      |
| C             | 0.100 | 0.140 |                | .110                       | .108  | .109  | .110  |    |      |
| D             | 0.210 | 0.230 |                | .219                       | .218  | .217  | .219  |    |      |
| E             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.250 |    |      |
| F             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.250 |    |      |
| G             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| H             | 0.510 | 0.515 |                | .514                       | .514  | .514  | .514  |    |      |
| I             | 1.572 | 1.582 |                | 1.577                      | 1.577 | 1.577 | 1.577 |    |      |
| J             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| K             | 0.257 | 0.262 |                | .258                       | .258  | .258  | .258  |    |      |
| L             | 0.312 | 0.317 |                | .314                       | .314  | .314  | .314  |    |      |
| M             | 0.235 | 0.240 |                | .238                       | .238  | .238  | .238  |    |      |
| N             | 0.100 | 0.140 |                | .122                       | .120  | .120  | .120  |    |      |
| O             | 0.540 | 0.560 |                | .551                       | .550  | .550  | .551  |    |      |
| P             | 0.490 | 0.510 |                | .501                       | .500  | .500  | .499  |    |      |
| Q             | 3.715 | 3.725 |                | 3.720                      | 3.720 | 3.720 | 3.720 |    |      |
| R             | 2.470 | 2.510 |                | 2.490                      | 2.490 | 2.490 | 2.490 |    |      |
| S             | 0.240 | 0.270 |                | .250                       | .250  | .250  | .250  |    |      |
| T             | 0.100 | 0.180 |                | .135                       | .135  | .135  | .135  |    |      |
| U             | 1.625 | 1.635 |                | 1.630                      | 1.630 | 1.630 | 1.630 |    |      |
| V             | 1.362 | 1.372 |                | 1.367                      | 1.367 | 1.367 | 1.367 |    |      |
| W             | 0.316 | 0.321 |                | .316                       | .316  | .316  | .316  |    |      |
| X             | 1.125 | 1.145 |                | 1.133                      | 1.135 | 1.135 | 1.134 |    |      |
| Y             | 1.565 | 1.585 |                | 1.572                      | 1.574 | 1.574 | 1.574 |    |      |
| Z             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |    |      |
| AA            |       |       |                |                            |       |       |       |    |      |
| AB            |       |       |                |                            |       |       |       |    |      |
| AC            |       |       |                |                            |       |       |       |    |      |
| AD            |       |       |                |                            |       |       |       |    |      |
| AE            |       |       |                |                            |       |       |       |    |      |
| AF            |       |       |                |                            |       |       |       |    |      |
| AG            |       |       |                |                            |       |       |       |    |      |
| AH            |       |       |                |                            |       |       |       |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|              |          |
|--------------|----------|
| Measured by: | PO       |
| Date:        | 13/04/22 |

|             |          |
|-------------|----------|
| Audited by: | SS       |
| Date:       | 13-04-25 |

| Rev | Date     | Change  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue   | RF         |          |
| B   | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF      |          |
| C   | 07.03.21 | Revised per drawing revision C                    | KJ/JLM     |          |

|   |                     |             |
|---|---------------------|-------------|
| <b>DART AEROSPACE LTD</b>                           | <b>Work Order:</b>  | 98161       |
| <b>Description:</b> 206 Saddle, Outboard, Left side | <b>Part Number:</b> | D2932-1     |
| <b>Inspection Dwg:</b> D2932 Rev. C                 |                     | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

|               |       |       |                | Recorded Actual Dimensions |       |       |       |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 15                         | 26    | 27    | 28    | By | Date |
| A             | 0.100 | 0.140 |                | .111                       | .114  | .111  | .112  |    |      |
| B             | 0.100 | 0.140 |                | .111                       | .114  | .112  | .112  |    |      |
| C             | 0.100 | 0.140 |                | .110                       | .108  | .109  | .110  |    |      |
| D             | 0.210 | 0.230 |                | .219                       | .219  | .218  | .219  |    |      |
| E             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.250 |    |      |
| F             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.250 |    |      |
| G             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| H             | 0.510 | 0.515 |                | .514                       | .514  | .514  | .514  |    |      |
| I             | 1.572 | 1.582 |                | 1.577                      | 1.577 | 1.577 | 1.577 |    |      |
| J             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| K             | 0.257 | 0.262 |                | .258                       | .258  | .258  | .258  |    |      |
| L             | 0.312 | 0.317 |                | .314                       | .314  | .314  | .314  |    |      |
| M             | 0.235 | 0.240 |                | .238                       | .238  | .238  | .238  |    |      |
| N             | 0.100 | 0.140 |                | .120                       | .120  | .119  | .120  |    |      |
| O             | 0.540 | 0.560 |                | .550                       | .550  | .551  | .550  |    |      |
| P             | 0.490 | 0.510 |                | .500                       | .501  | .495  | .500  |    |      |
| Q             | 3.715 | 3.725 |                | 3.720                      | 3.720 | 3.720 | 3.720 |    |      |
| R             | 2.470 | 2.510 |                | 2.490                      | 2.490 | 2.490 | 2.490 |    |      |
| S             | 0.240 | 0.270 |                | .251                       | .250  | .250  | .250  |    |      |
| T             | 0.100 | 0.180 |                | .135                       | .135  | .135  | .135  |    |      |
| U             | 1.625 | 1.635 |                | 1.630                      | 1.630 | 1.630 | 1.630 |    |      |
| V             | 1.362 | 1.372 |                | 1.367                      | 1.367 | 1.367 | 1.367 |    |      |
| W             | 0.316 | 0.321 |                | .316                       | .316  | .316  | .316  |    |      |
| X             | 1.125 | 1.145 |                | 1.134                      | 1.133 | 1.133 | 1.134 |    |      |
| Y             | 1.565 | 1.585 |                | 1.573                      | 1.572 | 1.572 | 1.574 |    |      |
| Z             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |    |      |
| AA            |       |       |                |                            |       |       |       |    |      |
| AB            |       |       |                |                            |       |       |       |    |      |
| AC            |       |       |                |                            |       |       |       |    |      |
| AD            |       |       |                |                            |       |       |       |    |      |
| AE            |       |       |                |                            |       |       |       |    |      |
| AF            |       |       |                |                            |       |       |       |    |      |
| AG            |       |       |                |                            |       |       |       |    |      |
| AH            |       |       |                |                            |       |       |       |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|              |          |
|--------------|----------|
| Measured by: | PO       |
| Date:        | 13/04/22 |

|             |          |
|-------------|----------|
| Audited by: | SA       |
| Date:       | 13-04-25 |

| Rev | Date     | Change  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue   | RF         |          |
| B   | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF      |          |
| C   | 07.03.21 | Revised per drawing revision C                    | KJ/JLM     |          |

|   |                             |
|---|-----------------------------|
| <b>DART AEROSPACE LTD</b>                           | <b>Work Order:</b> 98161    |
| <b>Description:</b> 206 Saddle, Outboard, Left side | <b>Part Number:</b> D2932-1 |
| <b>Inspection Dwg:</b> D2932 Rev. C                 | <b>Page 1 of 1</b>          |

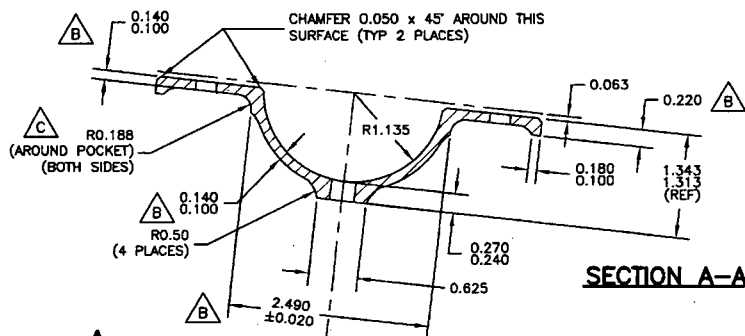
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |        |        |       | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|-------|----|------|
|               |       |       |                | 9                          | 10     | 11     | 12    |    |      |
| A             | 0.100 | 0.140 |                | .113                       | .113   | .113   | .113  |    |      |
| B             | 0.100 | 0.140 |                | .113                       | .114   | .114   | .114  |    |      |
| C             | 0.100 | 0.140 |                | .112                       | .114   | .114   | .112  |    |      |
| D             | 0.210 | 0.230 |                | .219                       | .219   | .220   | .218  |    |      |
| E             | 1.245 | 1.255 |                | 1.250                      | 1.250  | 1.250  | 1.250 |    |      |
| F             | 1.245 | 1.255 |                | 1.250                      | 1.250  | 1.250  | 1.250 |    |      |
| G             | 2.495 | 2.505 |                | 2.500                      | 2.500  | 2.500  | 2.500 |    |      |
| H             | 0.510 | 0.515 |                | .512                       | .512   | .512   | .512  |    |      |
| I             | 1.572 | 1.582 |                | 1.577                      | 1.577  | 1.577  | 1.577 |    |      |
| J             | 2.495 | 2.505 |                | 2.500                      | 2.500  | 2.500  | 2.500 |    |      |
| K             | 0.257 | 0.262 |                | .258                       | .258   | .258   | .258  |    |      |
| L             | 0.312 | 0.317 |                | .314                       | .314   | .314   | .314  |    |      |
| M             | 0.235 | 0.240 |                | .238                       | .238   | .238   | .238  |    |      |
| N             | 0.100 | 0.140 |                | .120                       | .119   | .120   | .120  |    |      |
| O             | 0.540 | 0.560 |                | .551                       | .551   | .551   | .551  |    |      |
| P             | 0.490 | 0.510 |                | .501                       | .500   | .499   | .501  |    |      |
| Q             | 3.715 | 3.725 |                | 3.720                      | 3.720  | 3.720  | 3.720 |    |      |
| R             | 2.470 | 2.510 |                | 2.491                      | 2.491  | 2.491  | 2.490 |    |      |
| S             | 0.240 | 0.270 |                | .253                       | .253   | .253   | .253  |    |      |
| T             | 0.100 | 0.180 |                | .135                       | .135   | .135   | .135  |    |      |
| U             | 1.625 | 1.635 |                | 1.630                      | 1.630  | 1.630  | 1.630 |    |      |
| V             | 1.362 | 1.372 |                | 1.367                      | 1.367  | 1.367  | 1.367 |    |      |
| W             | 0.316 | 0.321 |                | .316                       | .316   | .316   | .316  |    |      |
| X             | 1.125 | 1.145 |                | 1.134                      | 1.1325 | 1.1345 | 1.134 |    |      |
| Y             | 1.565 | 1.585 |                | 1.573                      | 1.572  | 1.574  | 1.574 |    |      |
| Z             | 0.178 | 0.198 |                | .188                       | .188   | .188   | .188  |    |      |
| AA            |       |       |                |                            |        |        |       |    |      |
| AB            |       |       |                |                            |        |        |       |    |      |
| AC            |       |       |                |                            |        |        |       |    |      |
| AD            |       |       |                |                            |        |        |       |    |      |
| AE            |       |       |                |                            |        |        |       |    |      |
| AF            |       |       |                |                            |        |        |       |    |      |
| AG            |       |       |                |                            |        |        |       |    |      |
| AH            |       |       |                |                            |        |        |       |    |      |
| Accept/Reject |       |       |                |                            |        |        |       |    |      |

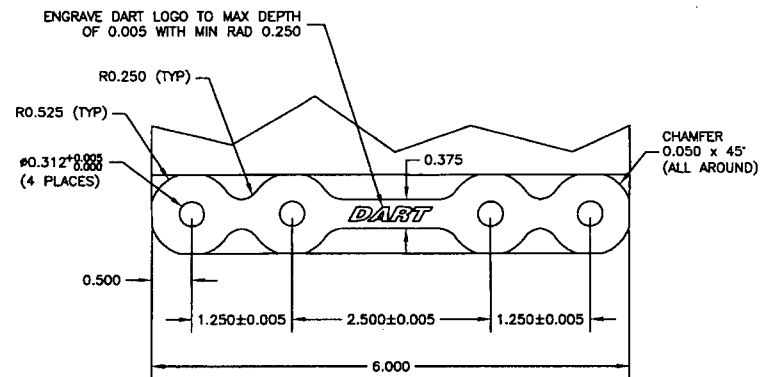
|                   |
|-------------------|
| Measured by: F.R. |
| Date: 13/04/23    |

|                         |
|-------------------------|
| Audited by: [Signature] |
| Date: 13-04-25          |

| Rev | Date     | Change  | Revised by         | Approved    |
|-----|----------|---|--------------------|-------------|
| A   |          | New Issue   | RF                 |             |
| B   | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF              |             |
| C   | 07.03.21 | Revised per drawing revision C                    | KJ/JLM [Signature] | [Signature] |



SECTION A-A



VIEW C-C

D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

|         |          |                               |
|---------|----------|-------------------------------|
| C       | 06.11.09 | R0.188 WAS R0.30 TO R0.25     |
| B       | 00.05.29 | CHANGED GEOMETRY AND MATERIAL |
| A       | 99.10.29 | NEW ISSUE                     |
| DESIGN  | BY       | DRAWN BY                      |
| CHECKED | PH       | APPROVED                      |
| DATE    | 06.11.09 | TITLE                         |
|         |          | SADDLE OUTSIDE                |

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**DART** DART AEROSPACE USA, INC.  
BELLVALE, WA

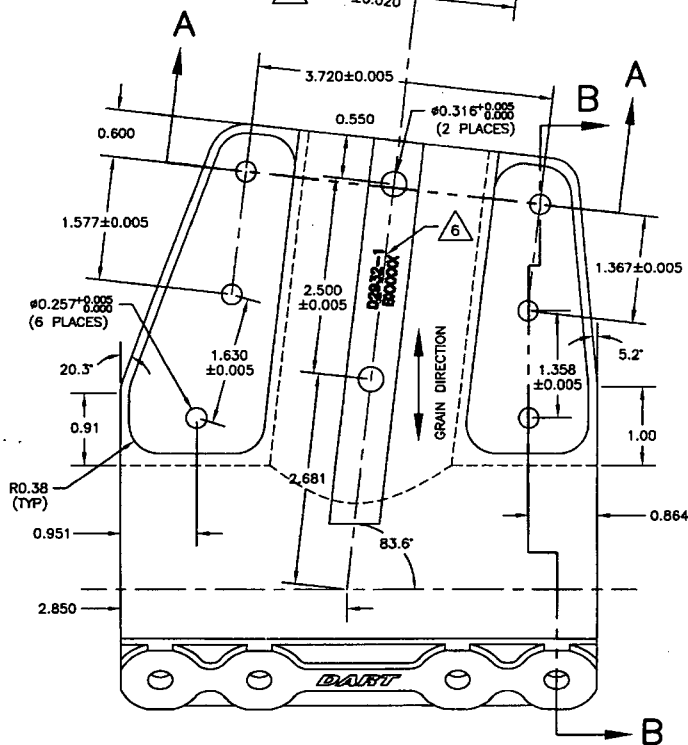
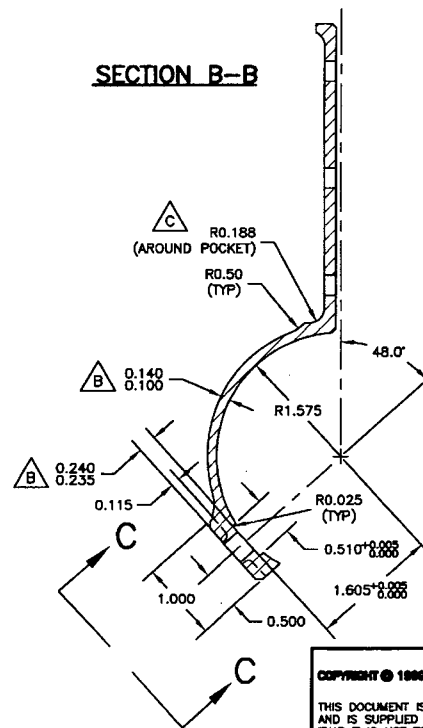
DRAWING NO. D2932

SHEET 1 OF 1

SCALE

2:3

SECTION B-B



RELEASED

07-02-02